

Work Order ID 60362

July 6, 2010 1:33:42 PM



Page 1

Item ID: D412-769-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Facing Seat, LH

Start Date: 7/06/10 Start Qty: 1.00



Cust Item ID:

Required Date: 7/20/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: CZ Date: 10/7/06 Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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IIN D412-769	Rev C
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100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D412-769-041 CHG 001

Label/ BJ 10-7-29
①

105

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

10/7/09 5/10
①

110

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

5/10/09

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No QA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60362

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Item ID: D412-769-041

Accept

Revision ID:

Item Name: Aft Facing Seat, LH

Start Date: 7/06/10 Start Qty: 1.00

Required Date: 7/20/10 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Setup Start

Stop

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Packaging	0.00							
	Packaging								
	Packaging								
	Memo	0.00							
	Identify and pack for shipping as per PPP D412-769-041								
	Location:								
	PPP Rev:								
130	QC21- Final Inspection - Work Order Release	0.00							
	QC								
	Quality Control								

PPP 60354

10/7/29

SP

10/07/29

Pl 10-729

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 60362



Parent Item: D412-769-041



Parent Item Name: Aft Facing Seat, LH

Start Date: 7/06/10

Required Date: 7/20/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev A 08-07-17 new issue DD verified by:EC IPP Rev:B
10.03.23 as per IIN revC DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D412-724-041 Head Rest Assembly, Center	CHG293	Manufactured	No			110	Each	0.0000	1	1		10/7/29	sp
D412-724-043 Head Rest Assembly, LH	CHG293	Manufactured	No			110	Each	1.0000	1	1		10/7/29	sp
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST191		1							
				58003		1							
D412-769-043 Aft Facing Seat Assembly, LH		Manufactured	No			110	Each	0.0000	1	1		10/7/29	sp

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4. WEIGHT AND BALANCE

The following is the weight increase associated with the D412-769-XXX Kits. The installer is responsible for the weight of the equipment coming out of the helicopter in order to install the D412-769-XXX Aft Facing Seat kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D412-769-011	60.0 lb	0.0 in	0.00 in-lb	87.0 in	5220 in-lb
Aft Facing Seat kit	27.2 kg	0.0 m	0.00 m-kg	2.21 m	60.11 m-kg
D412-769-041	30.0 lb	-16.1 in	-483.0 in-lb	87.0 in	2610 in-lb
Aft Facing Seat, LH (normal position)	13.6 kg	-0.41 m	-5.58 m-kg	2.21 m	30.06 m-kg
D412-769-042	30.0 lb	+16.1 in	+483.0 in-lb	87.0 in	2610 in-lb
Aft Facing Seat, RH (normal position)	13.6 kg	+0.41 m	+5.58 m-kg	2.21 m	30.06 m-kg
D412-769-041	30.0 lb	-1.1 in	-33.0 in-lb	87.0 in	2610 in-lb
Aft Facing Seat, LH (center position)	13.6 kg	-0.03 m	-0.41 m-kg	2.21 m	30.06 m-kg
D412-769-042	30.0 lb	+1.1 in	+33.0 in-lb	87.0 in	2610 in-lb
Aft Facing Seat, RH (center position)	13.6 kg	+0.03 m	+0.41 m-kg	2.21 m	30.06 m-kg
D412-769-041	30.0 lb	+13.9 in	+417.0 in-lb	87.0 in	2610 in-lb
Aft Facing Seat, LH (right Position)	13.6 kg	+0.35 m	+4.76 m-kg	2.21 m	30.06 m-kg
D412-769-042	30.0 lb	-13.9 in	-417.0 in-lb	87.0 in	2610 in-lb
Aft Facing Seat, RH (left Position)	13.6 kg	-0.35 m	-4.76 m-kg	2.21 m	30.06 m-kg

5. PARTS LIST

Qty -011	Qty -041	Qty -042	Part Number	Description
X			D412-769-011	AFT FACING SEAT KIT
1	X		D412-769-041	AFT FACING SEAT, LH
1		X	D412-769-042	AFT FACING SEAT, RH
	1		D412-769-043	AFT FACING SEAT ASSEMBLY, LH
		1	D412-769-044	AFT FACING SEAT ASSEMBLY, RH
	1	1	D412-724-041	HEAD REST ASSEMBLY, CENTER
		1	D412-724-043	HEAD REST ASSEMBLY, LH
		1	D412-724-044	HEAD REST ASSEMBLY, RH

25.9 Parts List

Qty -011	Qty -041	Qty -042	Part Number	Description
X			D412-769-011	AFT FACING SEAT KIT
1	X		D412-769-041	AFT FACING SEAT, LH
1		X	D412-769-042	AFT FACING SEAT, RH
	1	1	D412-724-041	HEAD REST ASSY, CENTER
	1	1	D3303-041	HEAD REST
	1	1	D3304-041	TUBE ASSEMBLY
	4	4	AN525-10R6	SCREW
	1		D412-724-043	HEAD REST ASSY, LH
	1		D3303-041	HEAD REST
	1		D3304-043	TUBE ASSEMBLY
	4		AN525-10R6	SCREW
		1	D412-724-044	HEAD REST ASSY, RH
		1	D3303-041	HEAD REST
		1	D3304-044	TUBE ASSEMBLY
		4	AN525-10R6	SCREW
	1		D412-769-043	AFT FACING SEAT ASSEMBLY, LH
		1	D412-769-044	AFT FACING SEAT ASSEMBLY, RH
	2	2	D3782-045	BACK LEG ASSEMBLY
	1	1	D3772-1	BACK LEG
	1	1	D3786-1	SLEEVE
	1	1	D3787-1	FOOT
	1	1	D3764-1	BACK LEG ADAPTER
	1	1	D3773-041	HEAD REST ADAPTER
	1	1	AN5-15A	BOLT
	1	1	AN45-15A	EYE BOLT
	1	1	AN5-17A	BOLT
	2	2	AN4-15A	BOLT
	4	4	NAS1149D0463J	WASHER
	5	5	NAS1149D0568J	WASHER
	2	2	MS21042L4	NUT
	3	3	MS21042L5	NUT
	1	1	D3782-041	FRONT INBOARD LEG ASSEMBLY
	1	1	D3768-1	FRONT INBOARD LEG
	1	1	D3762-041	FRONT LEG FITTING ASSY
	1	1	D3787-1	FOOT
	1	1	AN5-13A	BOLT
	3	3	NAS1149D0568J	WASHER
	2	2	MS21042L5	NUT
	1	1	AN45-13A	EYE BOLT
	1		D3782-043	FRONT OUTBOARD LEG ASSEMBLY, LH
	1		D3768-3	FRONT OUTBOARD LEG, LH
	1		D3762-041	FRONT LEG FITTING ASSY
	1		D3787-1	FOOT
	2		AN45-13A	EYE BOLT
	2		NAS1149D0568J	WASHER
	2		MS21042L5	NUT

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25-00-00

Revision: 1

REFERENCE ONLY

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ICA-D412-769

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Qty -011	Qty -041	Qty -042	Part Number	Description
		1	. D3782-044	FRONT OUTBOARD LEG ASSEMBLY, RH
		1	. D3768-4	FRONT OUTBOARD LEG, RH
		1	. D3762-041	FRONT LEG FITTING
		1	. D3787-1	FOOT
		2	. AN45-13A	EYE BOLT
		2	. NAS1149D0568J	WASHER
		2	. MS21042L5	NUT
1	1	1	. D3783-041	LATERAL BRACE ASSEMBLY
1	1	1	. D3769-1	TUBE
2	2	2	. D3765-1	CLEVIS
2	2	2	. AN5-13A	BOLT
4	4	4	. NAS1149D0568J	WASHER
2	2	2	. MS21042L5	NUT
2	2	2	. D3783-043	LONGITUDINAL BRACE ASSEMBLY
1	1	1	. D3769-3	TUBE
1	1	1	. D3765-1	CLEVIS
1	1	1	. AN5-13A	BOLT
2	2	2	. NAS1149D0568J	WASHER
1	1	1	. MS21042L5	NUT
1	1	1	. D3783-045	ANGLE BRACE ASSEMBLY
1	1	1	. D3769-5	TUBE
2	2	2	. D3765-1	CLEVIS
2	2	2	. AN5-13A	BOLT
4	4	4	. NAS1149D0568J	WASHER
2	2	2	. MS21042L5	NUT
1	1	1	. D3784-041	SEAT SUPPORT ASSEMBLY
1	1	1	. D3770-1	TUBE
1	1	1	. D3763-041	END FITTING ASSY
1	1	1	. D3763-045	END FITTING ASSY
2	2	2	. AN525-10R20	SCREW
4	4	4	. NAS1149D0332J	WASHER
2	2	2	. MS21042L3	NUT
1	1	1	. D3784-043	SEAT SUPPORT, LH
1	1	1	. D3762-043	END FITTING ASSY, LH
1	1	1	. D3770-1	TUBE
1	1	1	. D3770-3	TUBE
2	2	2	. D3763-041	END FITTING ASSY
4	4	4	. AN525-10R20	SCREW
4	4	4	. NAS1149D0332J	WASHER
4	4	4	. MS21042L3	NUT
1	1	1	. D3784-044	SEAT SUPPORT, RH
1	1	1	. D3762-044	END FITTING ASSY, RH
1	1	1	. D3770-1	TUBE
1	1	1	. D3770-3	TUBE
2	2	2	. D3763-041	END FITTING ASSY
4	4	4	. AN525-10R20	SCREW
4	4	4	. MS21042L3	NUT
8	8	8	. NAS1149D0332J	WASHER

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25-00-00

Revision: 1

Qty -011	Qty -041	Qty -042	Part Number	Description
	1		. D3766-1	FRONT RAIL, LH
		1	. D3766-2	FRONT RAIL, RH
	1	1	. D3766-3	REAR RAIL
	1	1	. D3767-1	UPPER RAIL
	1	1	. AN45-13A	EYE BOLT
	6	6	. AN5-10A	BOLT
	2	2	. AN5-13A	BOLT
	20	20	. NAS1149D0568J	WASHER
	4	4	. NAS1149D0463J	WASHER
	12	12	. MS21042L5	NUT
	2	2	. MS21042L4	NUT
	28	28	. MS21042L3	NUT
	2	2	. AN4-15A	BOLT
	1	1	. D412-724-041	HEAD REST ASSEMBLY, CENTER
	1		. D412-724-043	HEAD REST ASSEMBLY, LH
		1	. D412-724-044	HEAD REST ASSEMBLY, RH
	1	1	. D3774-1	SEAT BOTTOM
	1	1	. D3774-3	SEAT BACK
	13	13	. AN525-10R22	SCREW
	9	9	. AN525-10R24	SCREW
	21	21	. NAS1149D0363J	WASHER
	13	13	. NAS1149D0332J	WASHER
	6	6	. AN3-5A	BOLT
	2	2	. D3775-1	GUARD
	3	3	. D3792.1	SEAT BELT EYE BOLT

NOTE: . PART INCLUDED WITH ASSEMBLY ABOVE
 .. PART INCLUDED WITH ASSEMBLY ABOVE
 ... PART INCLUDED WITH ASSEMBLY ABOVE